

Date: Wednesday, 03/09/2008 10:36:53 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41769
 Estimate Number : 10265
 P.O. Number :
 This Issue : 03/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 41768
 Written By :
 Checked & Approved By : JLD 08.9.03
 Comment : Est Rev: I 02.09.25 Rearranged procedure steps KJ
 Est Rev: J 06-03-29 As per Rev D EC
 Est Rev: K 06-07.13 As per dsi9343 EC
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
 Verified By: EC
 Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC

Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Part Number : D350636012
 Drawing Number : D2750 UNDER REVIEW + DSI 943
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 30/09/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.9.24 509/09/27



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 003 004 03.09.04

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

41122SL 89-21

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

39242SL 89-21

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

SL 89-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube*****

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R

Aluminum Rod

M108708 / M107877

JE 8-9-22

10-Grind welds flush as per Dwg D2750

JE 08/09/22

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JO 8-9-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D 11-9-22

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B 411785

JO 8-9-22

W/O:		WORK ORDER CHANGES					
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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *B37584*

BE 08/09/24

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *B41136*

BE 08/09/24

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: *B40725*

BE 08/09/24

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: *B108801*

exp. date: *08-10-01*

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Aluminum Rod batch: M108708 BC 08/09/24

9-Grind welds flush as per Dwg D2750 JB 8-9-24

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750 JB 8-9-24

11-Deburr holes JB 8-9-24

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/09/24 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/24 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

HL 08-09-25 (X)

17.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

2:30

OVEN TEMPERATURE:

320

FINISH TIME:

3:00

M-A 08/09/25

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FL 08/09/26 (P)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M100621

HL 08-09-26 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

JH 08-09-26 (X)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B41114

JH

22.0

D353543

~~D3791-1~~ DSI 9413

Wearshoe

PH
08-09-04



D3793-1



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B40551

JH

*

23.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B41633

JH

24.0

D353533

~~D3791-3~~ DSI 9413

Wearshoe

PH
08-09-04



D3793-3



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B410552

JH

*

25.0

D353613

~~D3794-1~~ DSI 9413

Gasket

PH
08-09-04



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40533

JH

*

26.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B40729

JH

08-09-26 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0 D353635 **D3794-3** DSI 9413 Gasket

01.09.04



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: **B39713**

JA *

28.0 D35371 Wearpad



Comment: Qty.: **3.5** 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

DSI 9413

WEARPAD

Batch: **B41082**

JA

PTO →

29.0 D36311 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: **B41141**

JA

30.0 D3488042 Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: **B38787**

JA

31.0 D3492041 Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: **B41137**

JA

32.0 D3492043 Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: **B41138**

JA *

33.0 AN3C5A Bolt



Comment: Qty.: **34** 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Bolt

Batch: **M108928**

JA

08-09-26

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01-09-04	21.5	ADD D3791-1 per DSI 9413 B <u>39694</u>	PH JV	01-09-04 08-09-06	14 LL 1	PH 03-09-04	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M108880

JA

35.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch:

PTO

36.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M109091

JA

37.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M1106896

JA

38.0	AN960C10L	washer
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Comment: Qty.: 346.0000 Each(s)/Unit Total: 46.0000 Each(s)

washer

Batch: M108925

38 08-09-04

JA

39.0	AN960C816L	WASHER
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

WASHER

Batch: M1108928

1 08-09-04

JA

40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M108857

JA

08.09-26

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
01.09.04	35.5	ADD AN526C1032 R10 (QTY 4) 13 <u>14</u> 108062 " R18 (QTY 4) 13 <u>15</u> 23 D3672-1 (QTY 4) 13 <u>39</u> 275	DSF 9413 [Signature]	01.09.04 08.09.04	ALL	[Signature] 08.09.04		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M1108880

JA

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M108964

JA

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: _____

JA
08.09.04

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: M107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

C BATCH: M1108801

EXP DATE: 08/10

4-Coat all exposed fasteners with "LPS Procyon"

✓ batch: M104251

JA 08-09-26 *XL*

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/06 *XL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B40124

scf

48.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M108928

scf

49.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M108880

scf

50.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109092

scf

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M101581

scf

52.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B40829

8/9/29

scf

W/O:		WORK ORDER CHANGES					
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Job Number: 41769

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

D35321

Spacer



(12)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: B38594

B41846

8/9/09

SP

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/28/09/29 (X)

55.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev CA

8/9/29

SH

56.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

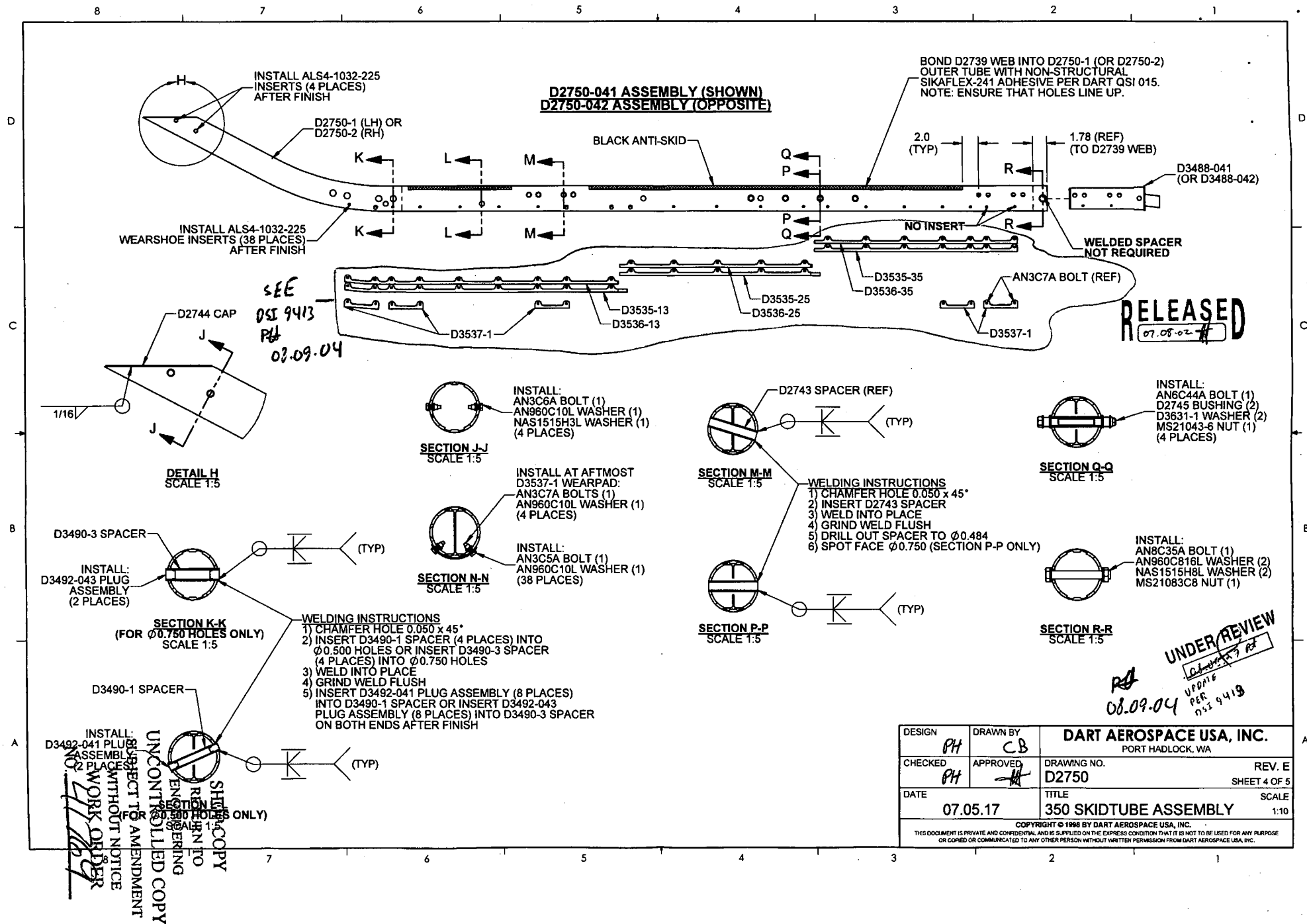
RELEASED
07-08-02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

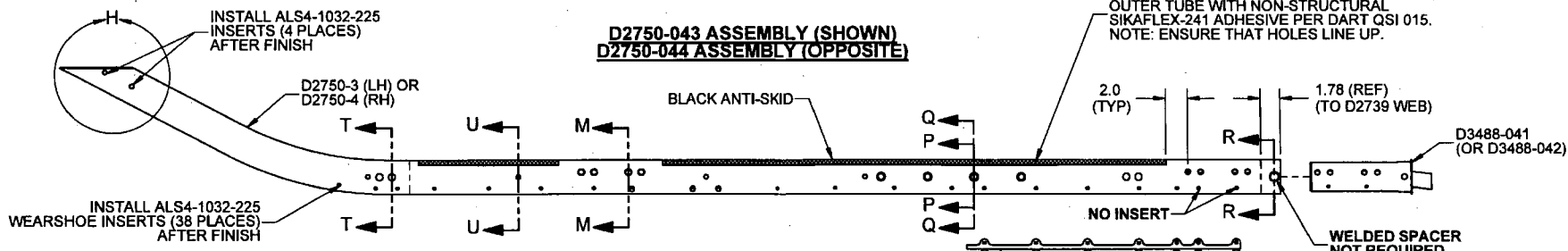
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8 7 6 5 4 3 2 1



**D2750-043 ASSEMBLY (SHOWN)
D2750-044 ASSEMBLY (OPPOSITE)**

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

D2750-3 (LH) OR
D2750-4 (RH)

BLACK ANTI-SKID

BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

2.0
(TYP)

1.78 (REF)
(TO D2739 WEB)

D3488-041
(OR D3488-042)

NO INSERT

WELDED SPACER
NOT REQUIRED

AN3C7A BOLT (REF)

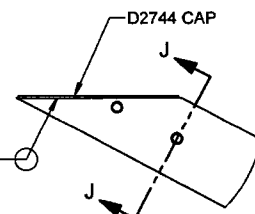
D3535-25
D3536-25

D3535-35
D3536-35

D3537-1

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UPDATE PER 052 9413

RELEASED
07.08.02



DETAIL H
SCALE 1:5

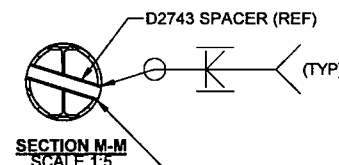
INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION J-J
SCALE 1:5

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

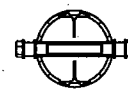
SECTION N-N
SCALE 1:5

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)



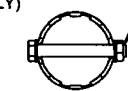
SECTION M-M
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D2743 SPACER
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) DRILL OUT SPACER TO Ø0.484
 - 6) SPOT FACE Ø0.750 (SECTION P-P ONLY)



SECTION Q-Q
SCALE 1:5

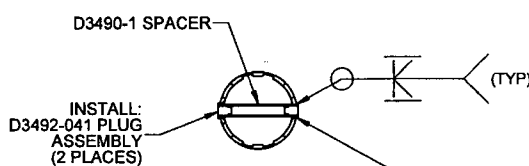
INSTALL:
AN8C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)



SECTION R-R
SCALE 1:5

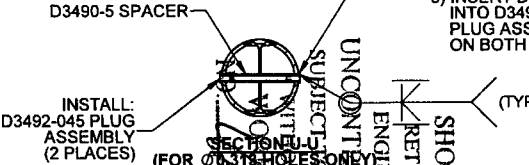
INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

UNDER REVIEW
DATE 07.07.17
UPDATE PER 052 9413



SECTION T-T
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS AFTER FINISH



SECTION U-U
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5

INSTALL:
D3492-045 PLUG
ASSEMBLY
(2 PLACES)

D3490-5 SPACER

D3490-1 SPACER

INSTALL:
D3492-041 PLUG
ASSEMBLY
(2 PLACES)

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DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10	

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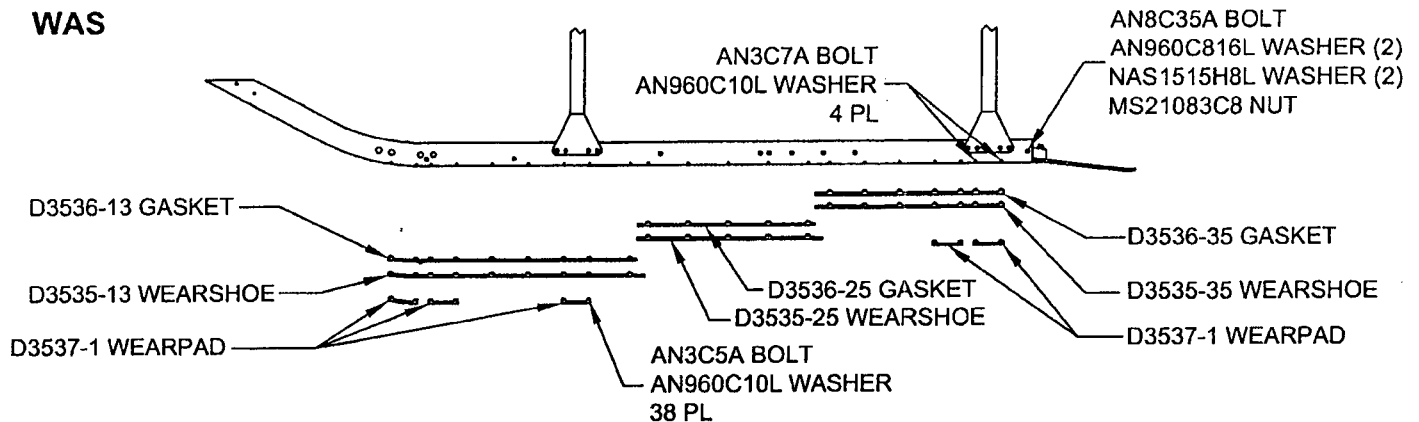
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

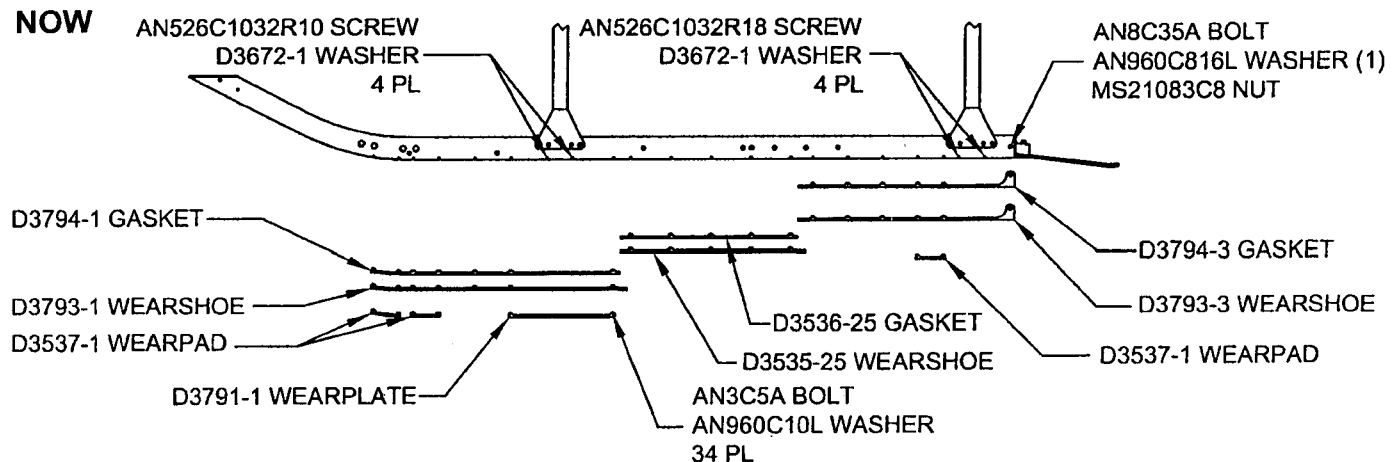


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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DE APPR.	<i>[Signature]</i>	WEARSHOE MODIFICATION	NTS
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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. NOTE: SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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NO. 168

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 41099
Part number: D350 636 012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]
pass[☒] fail[]

Penetration:

UNACCEPTABLE

Cracks:

pass[☒] fail[]
pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Pet. Paul Date of Test Coupon 08-08-21
Welder Barday Elliott Date of Test Coupon 08-08-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld